

Date: Thursday, 17/08/2006 3:17:49 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP EXTRUSION		
Job Number	: 28216					
Estimate Number	: 10113					
P.O. Number	: N/A		Part Number	: D2244116		
This Issue	: 17/08/2006	S.O. No. : N/A	Drawing Number	: D2244 REV D1		
Prsh Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: D1		
Previous Run	: N/A		Material	: N/A		
Written By	:		Due Date	: 30/09/2006 Qty: 80 Um: Each		
Checked & Approved By	:					
Comment	: Est: A 24.03.04 New Issue KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
Comment: PURCHASING Issue P/O: <u>1875</u> <i>C206108118</i> a) Extrude as per Dwg D2244 b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 38 ksi e) Minimum elongation = 8% f) Order at 116" long g) Caradon Indalex Tool # MH-18865 h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required		

2.0	D2244116P	Step Extrusion
Comment: Qty.: 1.0000 Each(s)/Unit Total : 80.0000 Each(s) STEP EXTRUSION		

3.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure certification are attached <i>B3 Oct/06/15 80</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/01/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP EXTRUSION

Job Number: 28216

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Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Check Pull test per Dwg D2244 for compliance page attached.

Check hardness with Webster tester

Jab.12.20

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock (in feet)

Location: W.A.

Jab.12.20
89

6.0 DC

DOCUMENT CONTROL



82

Comment: DOCUMENT CONTROL

Inspection Level 21

Jab.12.20
82/01/02

Job Completion



Jab.12.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

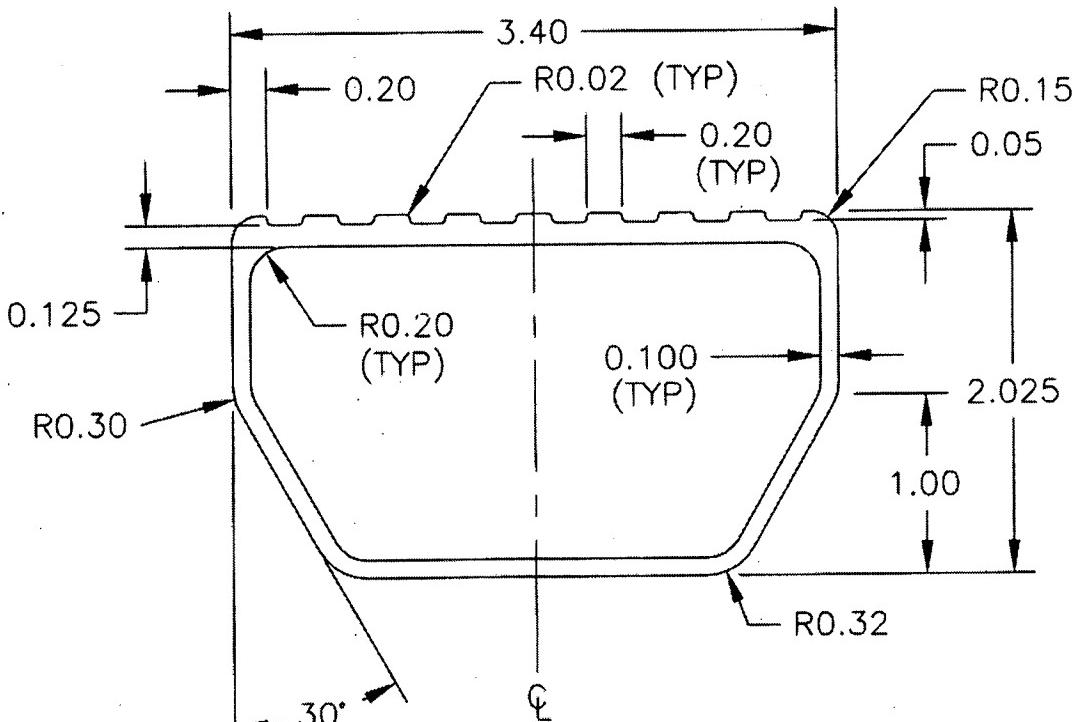
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RE</i>	APPROVED <i>PA</i>	DRAWING NO. D2244	REV. D SHEET 1 OF 1
DATE 98.11.18	TITLE STEP EXTRUSION		SCALE 1:1
A	94.07.05	NEW ISSUE	
B	94.07.11	REDESIGNED	
C	94.08.08	REDESIGNED	
D	98.11.18	REMOVED 6005A MATERIAL INCORPORATED DEO 9081	
D1	01.04.17	ADDED DIE # <i>CP</i>	

RELEASED
18.11.25 RE


PART NUMBER D2244-XX.X
XX.X IS CUT LENGTH IN INCHES

MATERIAL: 6061-T6 (QQ-A-200/8)

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM ELONGATION = 8%

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED



325 rue AVRO
Pointe-Claire QC H9R 5W3

Téléphone (514) 697-5120
Faximile (514) 694-8310

Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer :

DART AEROSPACE LTD

Adresse / Address :

270 ABERDEEN STREET
HAWKESBURY ONT,
KGA 1K7

commande Indalex / Indalex order # : 6082034

bon de commande / Purchase order # : 1875

de matrice / Die # : MS 18855 Description : Step Extrusion

Alliage & trempage / Alloy & temper : 6061 TG

Contrôle / Control # : 26130-1

Coulée / Cast # : 38621

	Min.requis Min.required	Résultat actuel Actual results
Tension ultime Ultimate stress (psi)	39 000	42258 ✓
Contrainte élastique Yield stress (psi)	35 000	37156 ✓
% élongation dans 2" % elongation in 2"	8	11 ✓
Dureté Rockwell E (hrs) Rockwell E Hardness (hrs)	88 @ 100	90 ✓

Composition chimique typique / Typical chemical composition :

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Tl
6063	0.20 - 0.60	0.35 Max	0.10 Max	0.10 Max	0.45 - 0.90	0.10 Max	0.10 Max	0.10 Max
6065	0.60 - 0.90	0.35 Max	0.10 Max	0.10 Max	0.40 - 0.60	0.10 Max	0.10 Max	0.10 Max
5008A	0.68 - 0.72	0.15 - 0.27	0.08 - 0.12	0.20 - 0.24	0.48 - 0.62	0.03 Max	0.05 Max	0.03 Max
6061	0.40 - 0.80	0.70 Max	0.15 - 0.40	0.18 Max	0.80 - 1.20	0.04 - 0.35	0.25 Max	0.15 Max
6341	0.7 - 1.3	0.5 Max	0.10 Max	0.40 - 1.80	0.40 - 0.80	-	0.20 Max	0.20 Max

Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par la norme ASTM B-221 et AMS QQA 200/8 ainsi que les exigences de nos procédures de contrôle de qualité.

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221 and AMS QQA 200/8 standard and requirements of our quality control procedures.

Sincèrement vôtre, . date : 2008-08-30
Yours truly,

Bruno Morenoy
Technicien de la qualité
Quality technician

Indalex Limited



INDALEX LIMITED
525 AVEO Street
POINTE-CLAIRE, QC H9B 3W1
TELEPHONE: (514) 697-5120 & (800) 563-5120
FACSIMILE: (514) 694-6310 & (800) 563-6310

FACSIMILE TRANSMITTAL SHEET

TO: Christina Young	FROM: Bruno Morency
	Quality Technician
COMPANY:	DATE:
DART AEROSPACE LTD	2006/08/30
FAK NUMBER:	TOTAL NO. OF PAGES INCLUDING COVER:
1(613) 632-4443	2
PHONE NUMBER:	SENDER'S REFERENCE NUMBER:
SUBJECT:	TIME:
REPORT	

URGENT FOR REVIEW PLEASE COMMENT PLEASE REPLY PLEASE RECYCLE

NOTES/COMMENTS:

Mechanical properties report.

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Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer : DART AEROSPACE LTD

Adresse / Address :
270 ABERDEEN STREET
HAWKESBURY ONT,
KGA 1K7

commande Indalex / Indalex order # : 6082034

bon de commande / Purchase order # : 1875

de matrice / Die # : MS 18865 Description : Step Extrusion

Alliage & trempage / Alloy & temper : 6061 T6

Contrôle / Control # : 26130-2

Coulée / Cast # : 38574

	Min. requis Min. required	Résultat actuel Actual result
Tension ultime Ultimate stress (psi)	38 000	39870 ✓
Contrainte élastique Yield stress (psi)	35 000	35617 ✓
% élongation dans 2" % elongation in 2"	8	11.5 ✓
Dureté Rockwell E (hrs) Rockwell E Hardness (hrs)	88 à 100	94 ✓

Composition chimique typique / Typical chemical composition :

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Al
6043	0.20 - 0.60	0.35 Max	0.10 Max	0.10 Max	0.45 - 0.90	0.10 Max	0.10 Max	0.10 Max
6005	0.60 - 0.90	0.35 Max	0.10 Max	0.10 Max	0.40 - 0.60	0.10 Max	0.10 Max	0.10 Max
6061	0.68 - 0.72	0.15 - 0.27	0.08 - 0.12	0.20 - 0.24	0.48 - 0.52	0.08 Max	0.05 Max	0.03 Max
6381	0.40 - 0.80	0.70 Max	0.15 - 0.40	0.15 Max	0.80 - 1.20	0.04 - 0.35	0.25 Max	0.15 Max

Nous certifions que le matériau fourni rencontre les exigences chimiques telles qu'annoncées par la norme ASTM B-221 et AMS QQA 200/8 ainsi que les exigences de nos procédures de contrôle de qualité.

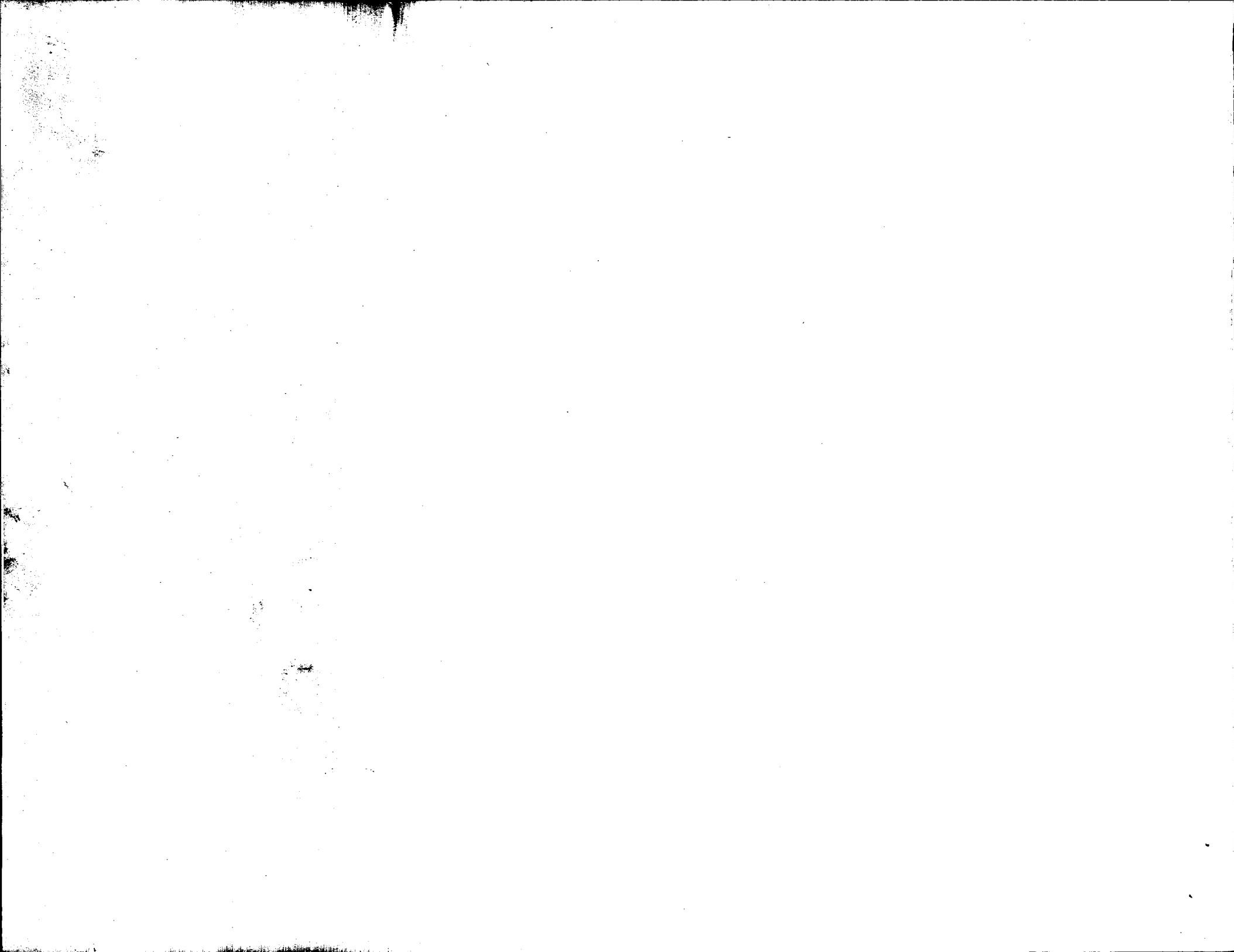
We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221 and AMS QQA 200/8 standard and requirements of our quality control procedures.

Sincèrement vôtre,
Yours truly,

date : 2006-06-06

Bruno Morinoy
Technicien de la qualité
Quality technician

Indalex Limited





INDALEX

ALUMINUM SOLUTIONS

INDIALEK LIMITED
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FACSIMILE TRANSMITTAL SHEET

to: Christina Young

**FROM: Bruno Morency
Quality Technician**

COMPANY

四

DART AEROSPACE LTD

2006/09/05

642-0000000000000000

www.123RF.com

FAX NUMBER:

1

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REPORT

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